

Work Order ID 134093

Monday, June 29, 2015 2:11:03 PM

134093

Ship July 10

15.07.03 PRELIMINARY ISSUE Page 1

Item ID: D205-803-213 Accept

Revision ID: ~~PRELIM~~ 15.07.03

Item Name: Left Hand Pilot in Command - Medium Design, Mechanical 205

N900040100 Setup Start *NS1*

Stop *NS2*

Start Date: 6/29/15 Start Qty: 12.00 *12*

Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 12.00 *12*

Customer:

Reference:

Approvals: Process Plan: 156-29 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D205-803	D

100	Document Control	0.00							DAS 27 9-89
100	DOCUMENT CONTROL								
DC	Memo	0.00							DAS 02 9-89
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D205-803-213 CHG001								JUN 15 2015

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							DAS 02 9-89
120									
QC	Memo	0.00							
Quality Control									JUL 15 2015

12
DAS
27
9-89
JUL 07 2015

ML 1507-07 12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 134093

134093

Page 2

Monday, June 29, 2015 2:11:03 PM

Item ID: D205-803-213 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM Stop ***NS2***
 Item Name: Left Hand Pilot in Command - Medium Design, Mechanical 205
 Start Date: 6/29/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 7/03/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							JUL 15 2015
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-803-213								
	Location: <u>EG 129</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 15.6.2015 AUTH LA

RELEASED _____ DATE _____

MUS JUL 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Monday, June 29, 2015 2:11:07 PM

134093

D205-803-213

Required Qty: 12.00

Comments: IPP REV:A 15.05.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5155-041		Manufactured	No				Each	0.0000	1	12			
D5155-041	DAS								**	134144		DAS	
Co-Pilot Collective Head Assembly (205)	02											6	
D5156-1	02	Manufactured	No				Each	12.0000	1	12		9-89	
D5156-1	DAS								**			27	
Face Plate	02											9-89	
	9-89												
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				st151			12			<u>12</u>			
				<u>132807</u>			12						
D5156-3		Manufactured	No				Each	12.0000	1	12			
D5156-3	DAS								**			27	
Face Plate	02											9-89	
	9-89												
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				st151			12			<u>12</u>			
				<u>132808</u>			12						
D4410-9		Manufactured	No				Each	18.0000	1	12			
D4410-9	DAS								**			27	
Trigger	02											9-89	
	9-89												
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST103			18			<u>12</u>			
				<u>116420</u>			18						
D5055-1		Manufactured	No				Each	20.0000	1	12			
D5055-1	DAS								**			27	
Placard	02											9-89	
	9-89												
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST144			20			<u>12</u>			
				<u>117708</u>			20						

JUL 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Work Order ID: 134093

134093

Parent Item: D205-803-213

D205-803-213

Parent Item Name: Left Hand Pilot in Command - Medium Design, Mechanical 205

Start Date: 6/29/15

Required Date: 7/03/15

Start Qty: 12.00

Required Qty: 12.00

D5055-3 Manufactured No

Each 32.0000 12

D5055-3

Placard

DAS
02
9-89

Location

Loc Qty

Loc Code

ST144

32

116627

1

117709

7

119593

12

132693

12

D4411-7 Manufactured No

Each 25.0000 12

D4411-7

Placard

DAS
02
9-89

Location

Loc Qty

Loc Code

ST104

25

117559

2

117704

11

132770

12

AN565F8H9 Purchased No

Each 43.0000 12

AN565F8H9

Set Screw

DAS
02
9-89

Location

Loc Qty

Loc Code

ST330

43

m128808

3

m129036

40

MS20253-1-065 MS20253-1-7200 Purchased No

Each 10.0000 12

MS20253-1-065

Hinge Pin

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

10

123522

10

Monday, June 29, 2015 2:11:07 PM

Shop Packet Print

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OTHER :																					

Picklist Print

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Parent Item: D205-803-213

D205-803-213

Parent Item Name: Left Hand Pilot in Command - Medium Design, Mechanical 205

Start Date: 6/29/15

Required Date: 7/03/15

Start Qty: 12.00

Required Qty: 12.00

MS21042L08

Purchased

No

Each

949.0000

12

MS21042L08

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

CA	101
m129682	101
ST260a	527
m131697	527
ST304	321
123900	16
m128401	102
m131317	203

**

DAS
27
9-89



MS21042L3

Purchased

No

Each

1,743.000

12

MS21042L3

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001	411
M130922	411
GA	461
M131317	461
ST305	871
116549	12
126333	49
M128754	2
M132123	25
M132382	783

**

DAS
27
9-89



MS21919WDG10

Purchased

No

Each

44.0000

12

MS21919WDG10

Clamp

DAS
02
9-89

Location

Loc Qty

Loc Code

ST296	44
m128993	44

**

DAS
27
9-89



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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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							Lead hand / Supervisor Approval Verification																		
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Picklist Print

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Work Order ID: 134093

134093

Parent Item: D205-803-213

D205-803-213

Parent Item Name: Left Hand Pilot in Command - Medium Design, Mechanical 205

Start Date: 6/29/15

Required Date: 7/03/15

Start Qty: 12.00

Required Qty: 12.00

MS21919WDG20

Purchased

No

Each

55.0000

12

MS21919WDG20

**

Clamp

DAS
02
9-89

Location

Loc Qty

Loc Code

ST273A

50

m128993

50

ST296

5

m128799

5

MS24693-24B

Purchased

No

Each

281.0000

48

MS24693-24B

**

Screw

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

281

m132256

281

MS27039-1-07

Purchased

No

Each

527.0000

12

MS27039-1-07

**

Screw

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

364

125654

364

ST286

163

m127813

155

m130388

8

9-89
27
DAS

9-89
27
DAS

9-89
27
DAS

JUL 6 2015

Monday, June 29, 2015 2:11:08 PM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Work Order ID: 134093

134093

Parent Item: D205-803-213

D205-803-213

Parent Item Name: Left Hand Pilot in Command - Medium Design, Mechanical 205

Start Date: 6/29/15

Required Date: 7/03/15

Start Qty: 12.00

Required Qty: 12.00

NAS1149D0363J

Purchased

No

Each

1,519.000

2

24

NAS1149D0363.1

Washer

DAS
27
9-89

DAS
6
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

CA	569	
m130799	569	
GA	168	
m128429	168	
ST269	782	
2799	4	
6140	8	
m126319	7	
m132317	763	

24

MS171539

Pin

Batch: m128911

1

12

DAS
27
9-89

DAS
6
9-89

JUL 9 6 2015

DAS
02
9-89

2+y1

15.07.03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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7. PARTS LIST - MEDIUM COLLECTIVE HEAD KITS

Qty -211	Qty -213	Qty -215	Qty -217	Qty -219	Qty -221	Qty -223	Part Number	Description
X							D205-803-211	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
	X						D205-803-213	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
		X					D212-803-215	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
			X				D212-803-217	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
				X			D212-803-219	LEFT HAND PILOT IN COMMAND, EAGLE SINGLE
					X		D205-803-221	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
						X	D205-803-223	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
1	1						D5155-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
		1	1				D5155-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
				1			D5155-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
					1	1	D5155-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205 WITH THE 204-001-290-5 STICK AND THROTTLE ASSY INSTALLED)
1	1			1	1	1	D5156-1	FACE PLATE
1	1			1	1	1	D5156-3	FACE PLATE
		1	1				D5156-5	FACE PLATE
		1	1				D5156-7	FACE PLATE
1	1			1	1	1	D4410-9	TRIGGER
1	1			1	1	1	D5055-1	PLACARD
1	1	1	1	1	1	1	D5055-3	PLACARD
		1	1				D5055-5	PLACARD
		1	1				D5055-7	PLACARD
		1	1				D5055-9	PLACARD
1	1	1	1	1			D4411-7	PLACARD
		1					27ET51-T	SWITCH (ALT P/N 212-075-153-3)
1					1		2PB744-T2	SWITCH
		3					30-037-26	DIODE ASSEMBLY
		2					30-037-3	DIODE ASSEMBLY
1	1			1	1	1	AN565F8H9	SETSCREW
		3					AN961-6T	WASHER
		1					51MX5-5-J	SWITCH
1					1		C100E2-39	SWITCH
17		AR (21)			17		M39029/31-240	PIN
17		AR (21)			17		M39029/32-259	SOCKET
		AR (2)					M39029/31-228	PIN
		AR (2)					M39029/32-247	SOCKET
1	1			1	1	1	MS20253-1-065	PIN
		3					MS21042L06	NUT
1	1			1	1	1	MS21042L08	NUT
1	1	1	1	1	1	1	MS21042L3	NUT
		2					MS21044N04	NUT
1	1	1	1	1			MS21919WDG10	CLAMP
		1	1	1			MS21919WDG19	CLAMP
1	1						MS21919WDG20	CLAMP
		1					MS24523-27	SWITCH
		2					MS24693-S7	SCREW
4	4	4	4	4	4	4	MS24693-24B	SCREW
1	1	1	1	1	1	1	MS27039-1-07	SCREW
		1					MS27212-1-3	TERMINAL BOARD
1					1		MS3126E14-19P	PLUG
1					1		MS3120E14-19S	SOCKET
		2					MS3126E16-99P	PLUG
		1					MS3120E16-99S	SOCKET
		3					MS3373-A1	STRIP
2	2	2	2	2			NAS1149D0363J	WASHER
					2	2	MS24693-209	COTTER PIN
1	1	1	1	1	1	1	D212-803	KIT PAPERWORK

4.0 PARTS LISTS**REFERENCE ONLY**DAS
02
9-89

Amend Parts Lists for the following kits per tables below.

4.1 Large Collective Head Kits

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Part Number	Description
X					D205-803-011	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
	X				D205-803-013	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
		X			D212-803-015	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
			X		D212-803-017	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
				X	D212-803-019	LEFT HAND PILOT IN COMMAND, EAGLE SINGLE
1	1				MS171539	PIN
		1	1	1	MS171599	PIN

4.2 Small Collective Head Kits

Qty -111	Qty -113	Qty -115	Qty -117	Qty -119	Part Number	Description
X					D205-803-111	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
	X				D205-803-113	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
		X			D212-803-115	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
			X		D212-803-117	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
				X	D212-803-119	LEFT HAND PILOT IN COMMAND, EAGLE SINGLE
1	1				MS171539	PIN
		1	1	1	MS171599	PIN

4.3 Medium Collective Head Kits

Qty -211	Qty -213	Qty -215	Qty -217	Qty -219	Part Number	Description
X					D205-802-211	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
	X				D205-803-213	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
		X			D212-803-215	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
			X		D212-803-217	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
				X	D212-803-219	LEFT HAND PILOT IN COMMAND, EAGLE SINGLE
1	1				MS171539	PIN
		1	1	1	MS171599	PIN

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9728	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.		LH PIC INSTALLATION	NTS
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